

Extrusion Processing Guidelines

PPC1TF5 (Any Color)

Barrel Tempertures

- Barrel Zone 1 176-193 °C
- Barrel Zone 2 176-193 °C
- Barrel Zone 3 182-204 °C
- Barrel Zone 4 187-210 °C

Roll Temperature

- Top 110-121 °C
- Middle 93-121 °C
- Bottom 60-71 °C

Die Temperatures

- Barrel Zone 1 193-221 °C
- Barrel Zone 2 193-221 °C

Material Drying is typically not required but for some applications drying may be required, if necessary dry at 160 – 190°F for 1-2 hours.

Machine Information

Screen Mesh	20-120 Mesh
Sizers	When Applicable
Screw Speeds	20-90 RPM

If you have any questions or require further processing information, please e-mail the Technical Service Group @ TechService@washpenn.com